

ASAP

Date: Thursday, 10/11/2007 2:54:56 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BRACKET	
Job Number	35133				
Estimate Number	11162				
P.O. Number	N/A		Part Number	D32641	
This Issue	10/11/2007	S.O. No.	S.O. No.	D3264 REV A	
Prsh Rev.	NC			N/A	
First Issue	N/A	Type	MACHINED PARTS	Project Number	A
Previous Run	34243			Drawing Revision	
Written By			Material	N/A	
Checked & Approved By			Due Date	11/5/2007	
Comment	Est	A	Qty:	14	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"
		Comment: Qty.: 0.5097 f(s)/Unit Total : 6.1160 f(s) Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick → 1.250 (M6061T6B1.250x04.500) Identify for D3264-1 Batch: M105531 <i>DSP 07/12/10</i>
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks: 4.500" x 1.250" x 5.700" long Bar <i>DSP 07/12/10</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA447 and Dwg D3264 Identify as D3264-1 Deburr <i>J.L / DSP 07/12/22</i> <i>(+14)</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>J.L / DSP 07/12/22</i> <i>(+14)</i>
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>JL 08.01/02 (+14)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D326H-1 PAR #: N/A Fault Category: Prod / Machine ^{PPAS} NCR: Yes No DQA: Date: 08/01/17
 QA: N/C Closed: _____ Date: _____

NCR: 35133		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/21	3	1 part is scrapped end-mill broke and caused deep mark in part. L.C. end mill broke.	✓ REWORK	Scrap + replaced Qty 1 part scraped M# 10553)	J.L 07/12/21	✓ Reworked	✓ Reworked	✓ 07/12/21
07/12/21	30	One part has the Ø.194" hole off by 0.006" over tol. L.C. part was too tight	LE 08-01-02	Acceptable	LE 08-01-02	✓ 08-01-02	LE 08-01-02	✓ 08-01-02
07/12/21	30	Wrong Saw blade used. One part has the Ø.194" hole off by 0.020" over tol. L.C. saw same as above.	LE 08-01-02	Acceptable	LE 08-01-02	✓ 08-01-02	LE 08-01-02	✓ 08-01-02

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:54:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 35133

Part Number: D32641

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MJ

08-01-10

X 14

7.0 POWDER COATING

POWDER COATING



M 106379



14X

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

MJ 08/01/10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MJ



X 14

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-10

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST164

10/11/10 (14)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

10/11/10

Job Completion



M 08-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35733
Description: Bracket	Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

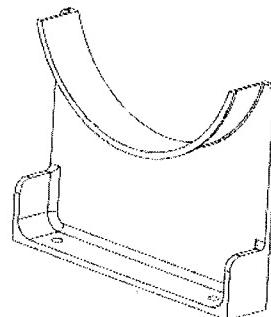
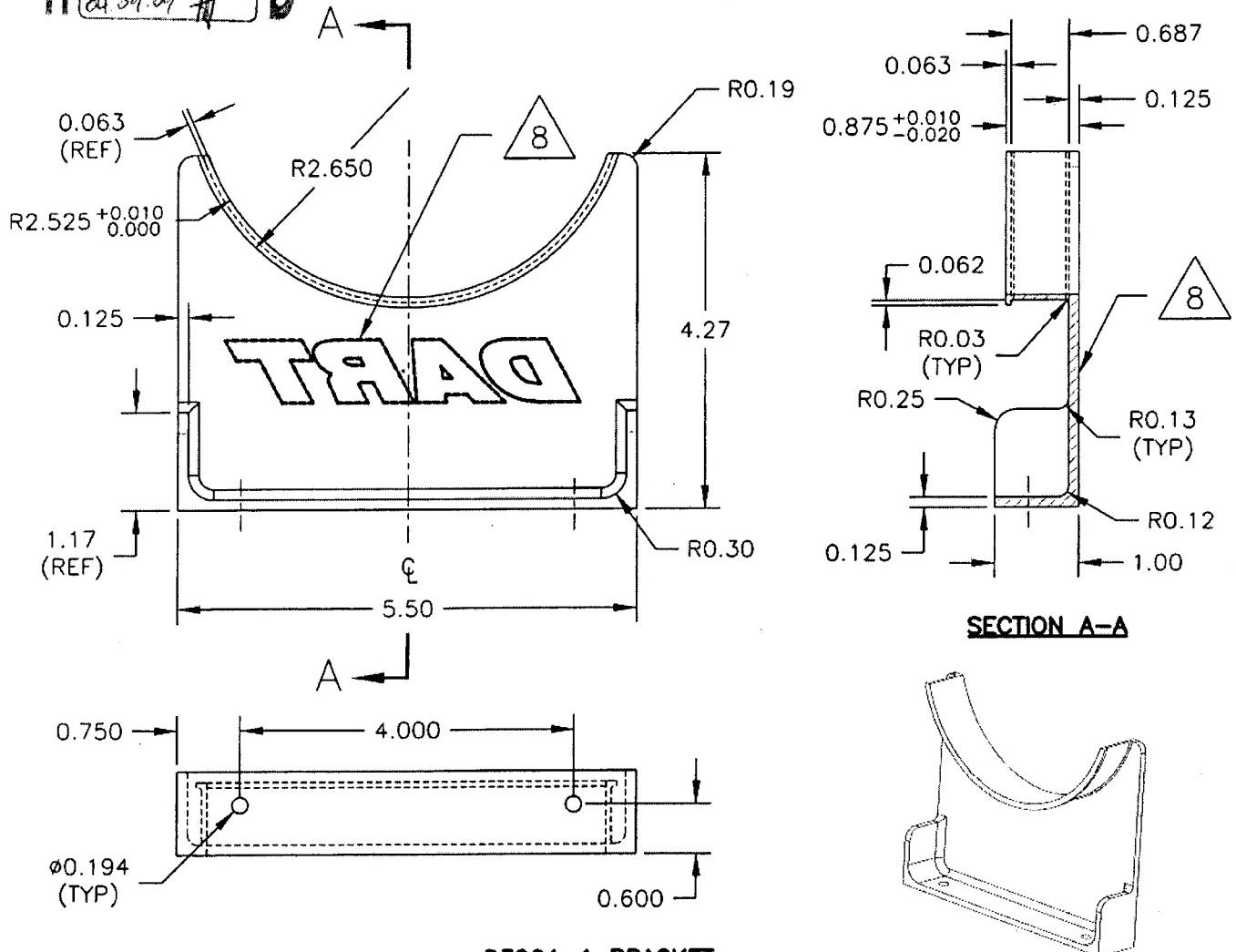
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.691	✓			
0.063	+/-0.010	.062	✓			
0.125	+/-0.010	.127	✓			
0.875	+0.010/-0.020	.877	✓			
0.062	+/-0.010	.063	✓			
R0.03	+/-0.030	.03	✓			
R0.13	+/-0.030	.13	✓			
1.00	+/-0.030	1.010	✓			
0.125	+/-0.010	.125	✓			
0.600	+/-0.010	.599	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	.750	✓			
Ø0.194	+0.005/-0.000	.198	✓			
5.50	+/-0.030	5.501	✓			
0.125	+/-0.010	.125	✓			
0.063	+/-0.010	.064	✓			
R0.25	+/-0.030	.25	✓			
4.27	+/-0.030	4.271	✓			
R0.30	+/-0.030	.30	✓			

Measured by:	J.L	Audited by:	S.F	Prototype Approval:	N/A
Date:	07/12/21	Date:	07/12/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	JK DS

DART

DESIGN <i>Rf</i>	DRAWN BY <i>Rf</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO.	D3264	REV. A
DATE 04.04.20		TITLE	BRACKET	SCALE 1:2
		A	04.04.20	NEW ISSUE

RELEASED
04.04.09 *[initials]***D3264-1 BRACKET****D3264-1:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH
(MIN) TOOL RADIUS OF 0.25

SHOP COPY
RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 35133

WITH